

# Work Order ID 62390

Wednesday, September 29, 2010 10:23:11 A



ASAP

Page 1

Item ID: D3084-3

Revision ID:

Item Name: Strut

Start Date: 9/30/2010 Start Qty: 2.00

Required Date: 10/6/2010 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: MF

Date: 10-9-29 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3084

B

100



Small Fab

Small Fab

BAND SAW

Memo

1- Punch per Dwg. D3084 and spec control dwg D2638  
2- Open hole to .3250 as per dwg, one side only  
3-Deburr

0.00

0.00

SB 10/09/30

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2

1005.30

120



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: M112860  
Large Fab


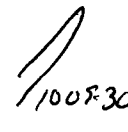
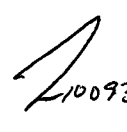
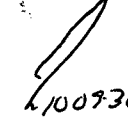
0.00

Memo

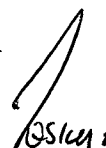
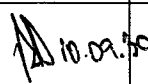
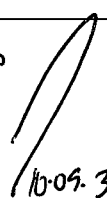
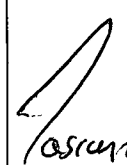

1- Weld ends per dwg.  
2- Grind flush

0.00

PD 10.10.01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-09-30	100	Hole sizes are 2X $\phi 0.257$ " per dwg, not $\phi 0.323$ per comment. $\phi 0.323$ is for the -1  perm change	HA	10-09-30		 100930	 100930	
10-09-30	150	Per drawing parts should be powder coated grey, not white. Change color. to match dwg.  perm change	HA	10-09-30		 100930	 100930	

Part No: D3084-3 PAR #: \_\_\_\_\_ Fault Category: Prod-eng coord NCR: Yes No DQA: Yes Date: 10-09-30  
 Resolution: documentation revised Disposition: other QA: N/C Closed: Yes Date: 10/04/2010

NCR: 62390		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-09-30	100 0 150	<ul style="list-style-type: none"> <li>Incorrect instruction for hole size - dwg shows <math>\phi .257</math>" - comment is <math>\phi .323</math></li> <li>W/O states to powder coat white &amp; dwg calls for grey.</li> <li>R.C. <del>not</del> IPP, not verified to dwg. <math>\Rightarrow</math> LOA</li> </ul>		<ul style="list-style-type: none"> <li>update / correct dwg per changes (above)</li> <li>Ensure to verify IPP per dwg instructions.</li> </ul>	 10-09-30			

NOTE: Date & initial all entries

# Work Order ID 62390

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Item ID: D3084-3

Revision ID:

Item Name: Strut

Start Date: 9/30/2010 Start Qty: 2.00

Required Date: 10/6/2010 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

2 - BE 10/10/04

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

81010104

(X2)

150



Powdercoat

Powder Coating

M112588

White Gloss (Ref 4.3.5.1) per QSI005 4.3-Alum

grey (4.3.5.6)

Memo

0.00

0.00

BR 10-10-4.

START TIME: 11:05

OVEN TEMPERATURE: 320°

FINISH TIME: 11:35

(2)

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62390

Wednesday, September 29, 2010 10:23:11 A



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Item ID: D3084-3

Accept



Setup Start



Revision ID:

Item Name: Strut

Stop



Start Date: 9/30/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/6/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				2	0		
170 	Identify as per dwg & Stock Location: <u>ST271</u>	0.00							
Packaging Packaging	Memo	0.00							
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

PC 10/10/09 (2)

10/10/05

ME  
10-10-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 29, 2010 10:23:11 AM

Page 1

Work Order ID: 62390



Parent Item: D3084-3



Parent Item Name: Strut

Start Date: 9/30/2010

Required Date: 10/6/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.750W.058		Purchased	No			100	f	142.2500	2.4833	5.228			



6061-T6 RD Tube .750 x.058W

Location

Loc Qty

Loc Code

MAT015

142.25

10099

34.25

112652

108

6 SS 09/29/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

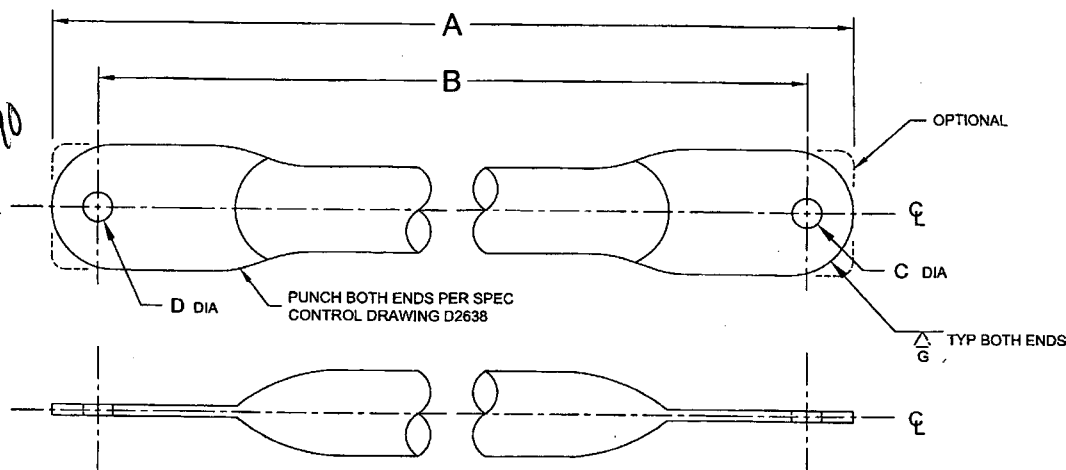
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



#62390



	A	B	C	D	WEIGHT	FINISH
D3084-1	37.18	36.38	0.257	0.323	0.46 lbs	WHITE POWDER COAT (4.3.5.1) PER DART QSI 4.3
D3084-3	29.80	29.00	0.257	0.257	0.37 lbs	GREY POWDER COAT (4.3.5.6) PER DART QSI 4.3

**D3084-XX STRUT**  
MAKE FROM DT3084-XX  
(XX IS THE RESPECTIVE DASH NUMBER)

10.09.29

UNDER REVIEW

10.09.29

**RELEASED**  
2010-04-19

MP

**NOTES:**

- MATERIAL: 6061-T6 OR 6061-T62 SEAMLESS TUBING  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8  
REF DART SPEC M6061T6T0.750V.058
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
SEE TABLE FOR POWDER COAT COLOR
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: NONE.
- WEIGHT: SEE TABLE
- WELD PER DART QSI 004.

DO NOT CHEM CONV. COAT

10.09.29

B	DRAWING REFORMAT. -3 ADDED. NOTES UPDATED	JPH	10.04.13
A	NEW ISSUE	CP	02.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3084	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		STRUT	NTS
DATE	10.04.13	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DME	APPROVED	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED  
98/09/05 KE

SPECIFICATION CONTROL DRAWING  
FOR PUNCH DT8117

